

Date: Thursday, 4/12/2007 8:20:44 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001-Dart Helicopters Services	Drawing Name	: SADDLE FITTING, FWD (OUTBOARD/INBOARD)
Job Number	: 31648		
Estimate Number	: 10531		
P.O. Number	: N/A	Part Number	: D2572
This Issue	: 4/12/2007	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2572 REV E
First Issue	: N/A	Project Number	: N/A
Previous Run	: 31146	Drawing Revision	: E
		Type	: MACHINED PARTS
		Material	: N/A
		Due Date	: 4/19/2007
Written By	:	Qty:	12 Um: Each
Checked & Approved By	:		
Comment	: Est. 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572 KJ		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101005	7075-T7351 8.25X5.0X2.5
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)
 7075-T7351 8.25X5.0X2.5
 Make from D6101-005 billet for D2572
 Ensure that grain is along 5.00" length
 Batch No: B25350 X12

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Program Batch No. B31648 Double check by: J.F.

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets
 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets
 4-Deburr and remove all machining marks
 5-Tumble to remove shap edges.

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
 Machine keyway as per dwg D2571 & D2572

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/12/2007 8:20:44 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 31648

Part Number: D2572

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

21 07/05/27 12

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

07/05/28 12

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M 103/41 BR/MH 07/05/29 17

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

07/05/29 11

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/05/29 11

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/05/30 16

Job Completion



07.05.30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2572 PAR #: N/A Fault Category: Prod / Finishing NCR: Yes No DQA: Yes Date: 07/05/30
 QA: N/C Closed: Yes Date: 07.05.30

NCR: <u>31648</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
070529	6.0	1 part scrap left in the Acid etch tank for 24 hrs. R.C. Employee did not check tank c. Qty.	<u>AS10/12</u>	<u>electrolyte. Ensure employee's check tanks c. Qty when chemical conversion coating.</u>	<u>070529</u>	<u>07/05/30</u>	<u>07/05/29</u>	<u>070529</u>

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	31648
Description: Saddle, Fwd Inboard	Part Number:	D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.440	0.440	0.440	0.440		
B	1.745	1.755		1.747	1.747	1.749	1.747		
C	3.495	3.505		3.499	3.501	3.499	3.500		
D	1.745	1.755		1.747	1.747	1.748	1.747		
E	7.990	8.010		8.002	8.002	8.003	8.003		
F	0.490	0.510		0.499	0.503	0.499	0.497		
G	0.257	0.262	DT8683	0.260	0.260	0.260	0.260		
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377		
I	0.490	0.510		0.496	0.497	0.496	0.496		
J	1.174	1.184		1.176	1.175	1.175	1.176		
K	0.558	0.578		0.565	0.563	0.561	0.561		
L	1.174	1.184		1.176	1.175	1.175	1.176		
M	1.490	1.500		1.494	1.492	1.494	1.491		
N	2.495	2.505		2.496	2.496	2.498	2.496		
O	3.869	3.879		3.873	3.872	3.872	3.873		
P	0.115	0.135		0.127	0.126	0.127	0.126		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.252	0.251	0.252	0.253		
S	0.115	0.135		0.121	0.121	0.120	0.122		
T	0.178	0.198		0.188	0.188	0.188	0.189		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.237	0.239	0.233	0.238		
W	0.115	0.135		0.125	0.125	0.122	0.120		
X	0.307	0.312		0.312	0.311	0.311	0.311		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.365	0.365	0.360	0.360		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.627	0.627	0.625	0.626		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.249	0.246	0.246	0.246		
AE	1.375	1.395		1.387	1.389	1.389	1.387		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.247	0.246	0.244	0.247		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.032	0.032	0.032	0.032		
Accept/Reject									

Measured by:	MS/En
Date:	07/05/24

Audited by:	SA
Date:	07/05/24

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order:	31648
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B	1.745	1.755		1.748	1.746	1.747	1.749		
C	3.495	3.505		3.499	3.500	3.501	3.506		
D	1.745	1.755		1.748	1.746	1.747	1.749		
E	7.990	8.010		8.001	8.001	8.001	8.002		
F	0.490	0.510		0.498	0.497	0.500	0.502		
G	0.257	0.262	DT8683	0.260	0.260	0.260	0.260		
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377		
I	0.490	0.510		0.496	0.498	0.498	0.496		
J	1.174	1.184		1.177	1.178	1.178	1.177		
K	0.558	0.578		0.565	0.565	0.566	0.559		
L	1.174	1.184		1.177	1.178	1.178	1.177		
M	1.490	1.500		1.492	1.494	1.494	1.493		
N	2.495	2.505		2.498	2.498	2.497	2.498		
O	3.869	3.879		3.873	3.871	3.872	3.870		
P	0.115	0.135		0.126	0.126	0.125	0.126		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.252	0.257	0.251	0.251		
S	0.115	0.135		0.124	0.124	0.124	0.125		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.239	0.238	0.237	0.241		
W	0.115	0.135		0.122	0.125	0.125	0.131		
X	0.307	0.312		0.311	0.312	0.311	0.310		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.360	0.360	0.360	0.360		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.624	0.625	0.626	0.629		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.243	0.246	0.247	0.248		
AE	1.375	1.395		1.387	1.387	1.386	1.387		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.247	0.248	0.247	0.251		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	EO 19m
Date:	07/05/27

Audited by:	JL
Date:	07/05/27

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order:	31648
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Inspection Dwg: D2572 Rev. E		Page 1 of 1

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B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.001	8.001		
F	0.490	0.510		0.501	0.503	0.502	0.502		
G	0.257	0.262	DT8683	0.258	0.258	0.258	0.258		
H	0.375	0.380	DT8684	0.376	0.376	0.376	0.376		
I	0.490	0.510		0.502	0.502	0.504	0.504		
J	1.174	1.184		1.177	1.177	1.177	1.177		
K	0.558	0.578		0.569	0.570	0.573	0.573		
L	1.174	1.184		1.177	1.177	1.177	1.177		
M	1.490	1.500		1.493	1.493	1.494	1.494		
N	2.495	2.505		2.498	2.499	2.500	2.500		
O	3.869	3.879		3.871	3.871	3.871	3.871		
P	0.115	0.135		0.125	0.126	0.127	0.127		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.250	0.251	0.251	0.251		
S	0.115	0.135		0.121	0.124	0.127	0.126		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.966		
V	0.230	0.250		0.242	0.241	0.241	0.241		
W	0.115	0.135		0.130	0.126	0.128	0.129		
X	0.307	0.312		0.311	0.310	0.310	0.310		
Y	0.760	0.765		0.761	0.761	0.761	0.761		
Z	0.352	0.372		0.361	0.354	0.353	0.357		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.630	0.630	0.630	0.631		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.246	0.251	0.249	0.249		
AE	1.375	1.395		1.386	1.387	1.387	1.387		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.240	0.245	0.245	0.245		
AH	0.240	0.260		0.250	0.251	0.249	0.249		
AI	2.000	2.020		2.002	2.003	2.004	2.003		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

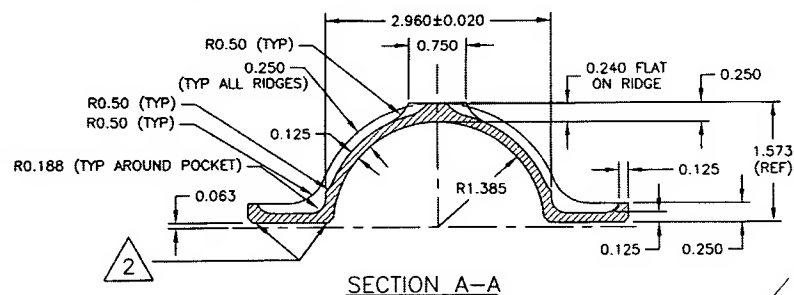
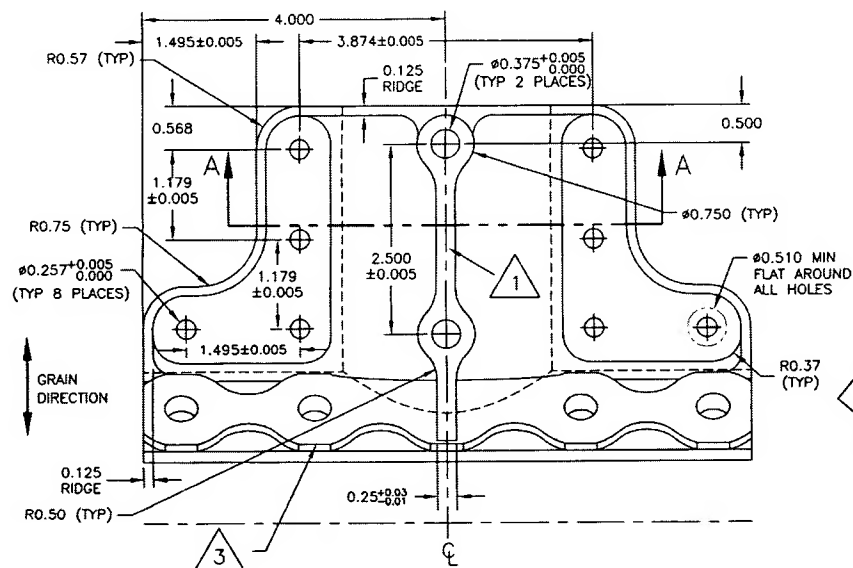
Measured by:	JK
Date:	07/05/27

Audited by:	JL
Date:	07/05/27

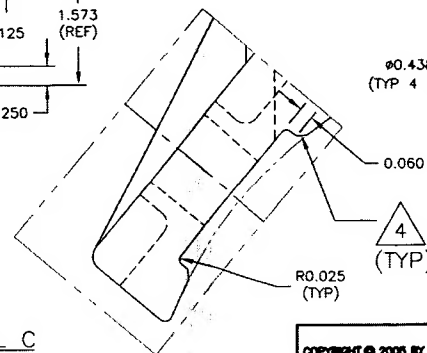
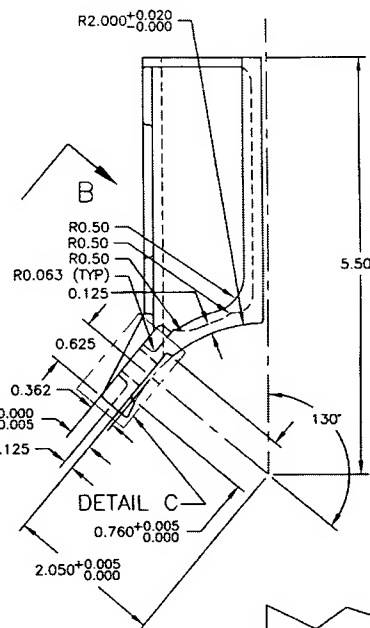
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

RELEASED

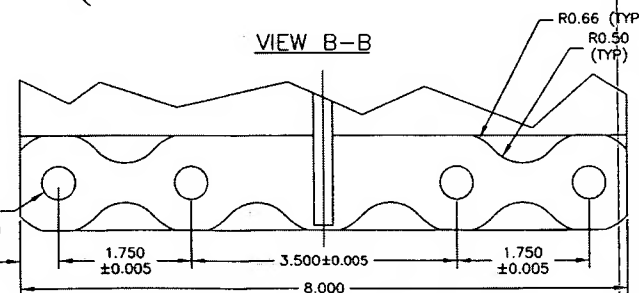
05.12.06



SECTION A-A

DETAIL C
SCALE 2:1

VIEW B-B



NOTES

MATERIAL: 7075-T7351 (00-A-250/12)
(REF DART SPEC. D6102-003)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
2 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
3 CHAMFER 0.063 x 45° ALL AROUND
4 CHAMFER 0.033 x 45° (SEE DETAIL C) E

E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4	
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES	
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177	
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425	
A	96.09.16	NEW ISSUE	
DESIGN	DS	DRAWN BY	PH
CHECKED		APPROVED	
DATE	05.07.13	TITLE	INNER FWD SADDLE
		DRAWING NO.	D2572
		SCALE	2:3
		REV. E	SHEET 1 OF 1

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